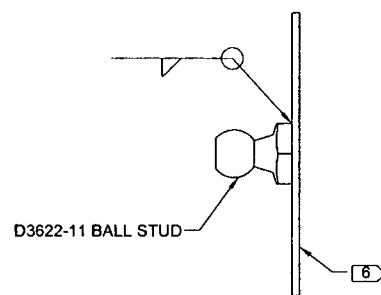
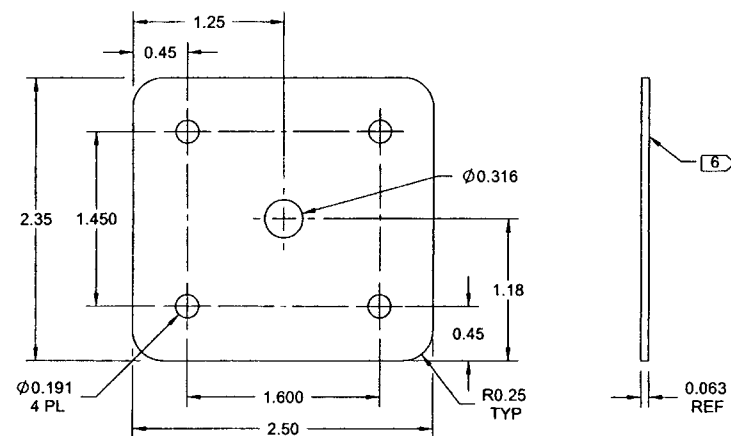


D4109-3 PLATE



D3622-11 BALL STUD

# **D4109-043 DOUBLER ASSEMBLY**



D4109-3 PLATE

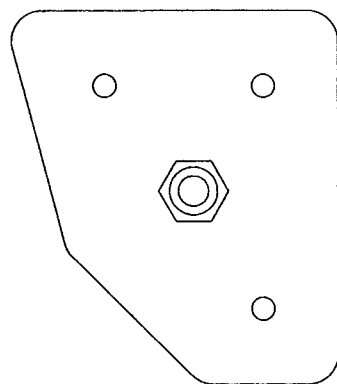
62504

**RELEASED**  
2010-09-23

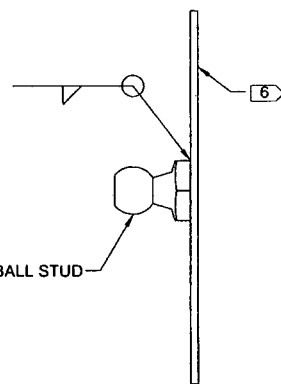
## **NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4109-X & B/N PER QSI 044 6.1
- 7) WEIGHT-043: 0.12 lbs
- 8) WELD PARTS PER QSI 004.

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D4109	SHEET 3 OF 3
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	DOUBLER ASSEMBLY	NTS
DATE	10.07.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

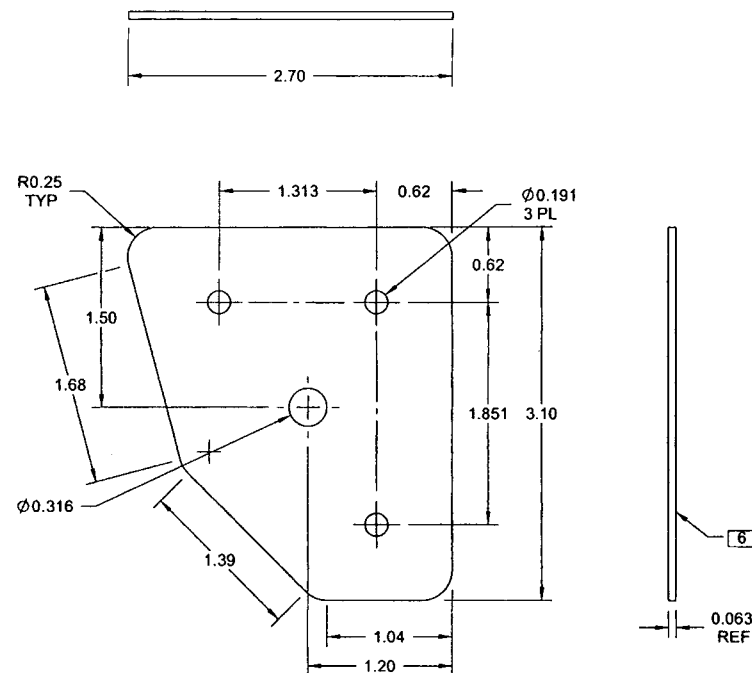


D4109-1 PLATE, BULKHEAD



D3622-11 BALL STUD

**D4109-041 DOUBLER ASSEMBLY, BULKHEAD**



**D4109-1 PLATE, BULKHEAD**

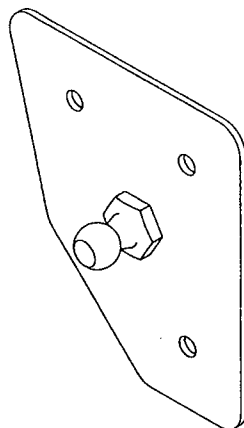
**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: IDENT P/N D4109-X & B/N PER QSI 044 6.1
- 7) WEIGHT -041: 0.14 lbs
- 8) WELD PARTS PER QSI.004.

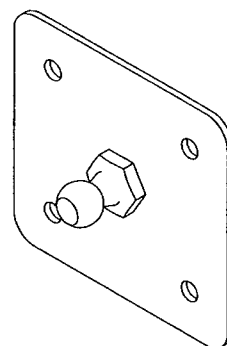
DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO.	REV. A
MFG. APPR.	JPH	D4109	SHEET 2 OF 3
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	DOUBLER ASSEMBLY	NTS
DATE	10.07.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRINTED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

**RELEASED**  
2010-09-23

Qty	Qty	Part Number	Description
-041	-043		
		D4109-041	DOUBLER ASSEMBLY, BULKHEAD
		D4109-043	DOUBLER ASSEMBLY
1		D4109-1	PLATE, BULKHEAD
1	1	D4109-3	PLATE
1	1	D3622-11	BALL STUD



**D4109-041 DOUBLER ASSEMBLY, BULKHEAD**



**D4109-043 DOUBLER ASSEMBLY**

*who  
62504*

**RELEASED**  
R 2010-09-23  
MP

A		NEW ISSUE		JPH	10.07.20
REV.	DESCRIPTION			BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN	JPH				
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A		
MFG. APPR.	<i>[Signature]</i>	D4109	SHEET 1 OF 3		
APPROVED	<i>[Signature]</i>	TITLE	SCALE		
DE APPR.	<i>[Signature]</i>	DOUBLER ASSEMBLY	NTS		
DATE		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			
10.07.20					

# Picklist Print

October 1, 2010 10:03:08 AM

Page 1

Work Order ID: 62504

Parent Item: D4109-043

Parent Item Name: Doubler Assembly





Start Date: 10/01/10

Required Date: 10/04/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3622-11  Ball Stud		Manufactured	No			100	Each	0.0000	1	2			
D4109-3  Plate		Manufactured	No			100	Each	0.0000	1	2			

B62505 @ 10/10/02

B62507 @ 10/10/02

# Work Order ID 62504

October 1, 2010 10:03:09 AM



Page 2

Item ID: D4109-043  
Revision ID:  
Item Name: Doubler Assembly  
Start Date: 10/01/10 Start Qty: 2.00  
Required Date: 10/04/10 Req'd Qty: 2.00  
Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:  
QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

130

Identify as per dwg & Stock Location: 130

0.00



Packaging

Memo

0.00

Packaging

10.10.12 (2)

140

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10.10.12

10.10.15 (2)

# Work Order ID 62504

October 1, 2010 10:03:09 AM



Page 1

Item ID: D4109-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler Assembly

Start Date: 10/01/10 Start Qty: 2.00



Cust Item ID:

Required Date: 10/04/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4109

A

100

Weld per dwg A/R S.S. rod Batch: M114649 0.00



Large Fab

Memo

0.00

Large Fab

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

10/10/02 (2x)

(2) 10.10.04

(x2)

8 10/10/04